



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-589-011
Job Sheet 171421



Part No: D350-589-011

Job Qty: 5 ea

Part Name: Side Door Latch Modification



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG INN-D350-589 REV E, DSI9760-013 IPP F 02.08.29 Removed D2587 Plug KJ ALL AT CHANGE 002

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	2/9/18	2/9/18	0.00	0.00	Start Up Stores/Pkg-2		
105	Packaging	5 pcs	2/9/18	2/9/18	0.00	0.00	Packaging1-3		
110	QC	5 pcs	2/9/18	2/9/18	0.00	0.00	QC4		
115	DC	5 pcs	2/9/18	2/9/18	0.00	0.00	DC		
120	Packaging	5 pcs	2/9/18	2/9/18	0.00	0.00	Packaging3-1		
130	QC21-FG	5 Ea	2/9/18	2/9/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2237	Striker Plate	15 Ea (3 ea)	90-Start up Operation	
D2583	Latch Bracket	15 Ea (3 ea)	90-Start up Operation	
D2585	Latch Clamp	15 Ea (3 ea)	90-Start up Operation	
D2586	Door Latch	15 Ea (3 ea)	90-Start up Operation	
D2587	Door Plug	5 Ea (1 ea)	90-Start up Operation	
D2589	Keys, Key Chain	5 Ea (1 ea)	90-Start up Operation	
MS20470AD4-5	Rivet, Universal Head	30 Ea (6 ea)	90-Start up Operation	
MS21042L3	Nut	15 Ea (3 ea)	90-Start up Operation	
MS27039-1-15	Screw	15 Ea (3 ea)	90-Start up Operation	
NAS1149D0363J	Washer	15 Ea (3 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2237	15	31	0
	D2583	15	0	0
	D2585	15	1	0
	D2586	15	54	0
	D2587	5	0	0
	D2589	5	3	0
	MS20470AD4-5	30	2,528	0
	MS21042L3	15	2,262	0
	MS27039-1-15	15	199	0
	NAS1149D0363J	15	3,829	0

Part Specifications

Specifications could not be found.



Container No: S043762



Part: D350-589-011

Job No: 171421

Serial No/Batch: S043762

Revision: INN-D350-589, DSI9760-013

Inspector:

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Date: 02/20/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 000717

Tel (613) 632-5200

Containers on Master Unit 000717				
Serial No	Part No	Customer Part No	Status	Quantity
F161798	D2585	D2585	Allocated	1
S040962	D2585	D2585	Allocated	14
S040954	D2586	D2586	Allocated	15
S040948	D2587		Allocated	5
FM136851-3	MS20470AD4-5		Allocated	7
S040947	MS20470AD4-5		Allocated	23
S040946	MS21042L3	MS21042L3	Allocated	15
S040944	MS27039-1-15		Allocated	15
S040943	NAS1149D0363J	NAS1149D0363J	Allocated	15

D2583 X 15 504760

D2237 X 15 5043759

~~D2237 50481221 X14~~

D2589 F132942

Change Record

PAGE 1 OF 1

Part Number: D350-589-011

Description: SIDE DOOR LATCH MODIFICATION INSTALLATION

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____ _____ _____			
Misidentified ☐	☐	Past Due ☐	☐				

REFERENCE ONLY

3.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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Revision: E

Date: 02.02.22